

# Work Order ID 71685

Thursday, July 07, 2011 12:13:44 PM



Page 1

Item ID: D3259-4	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Doubler					
Start Date: 7/7/2011	Start Qty: 8.00		Cust Item ID:		
Required Date: 7/21/2011	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CD</u>	Date: <u>11/07/07</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
<u>2024.063</u>	1-Cut as per Dwg D3259		<input checked="" type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-				
	Deburr if necessary								

B 11-8-12

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B 11-8-12

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

S 11/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71685

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Item ID: D3259-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-C'Sink Holes as per Dwg D3259

SB 11/08/15 (8)

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3259

SB 11/08/15

(8)

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

SB 11/08/15

(48)

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71685

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Item ID: D3259-4

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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8X *[Signature]* 11/08/2011

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*[Signature]* 11/08/2011

180

Identify as per dwg & Stock Location *ST 1809*

0.00



Packaging

Memo

0.00

Packaging

8X *[Signature]* 11-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3259-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/30  
mf  
11-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 07, 2011 12:13:42 PM

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Work Order ID: 71685

Parent Item: D3259-4

Parent Item Name: Doubler




Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063  2024-T3 .063 sheet		Purchased	No			100	sf	250.3800	1.388	11.68842			

B1-8-12

Location

Loc Qty

Loc Code

MAT022

250.38

117018

25.88

117392

224.5

117392

8

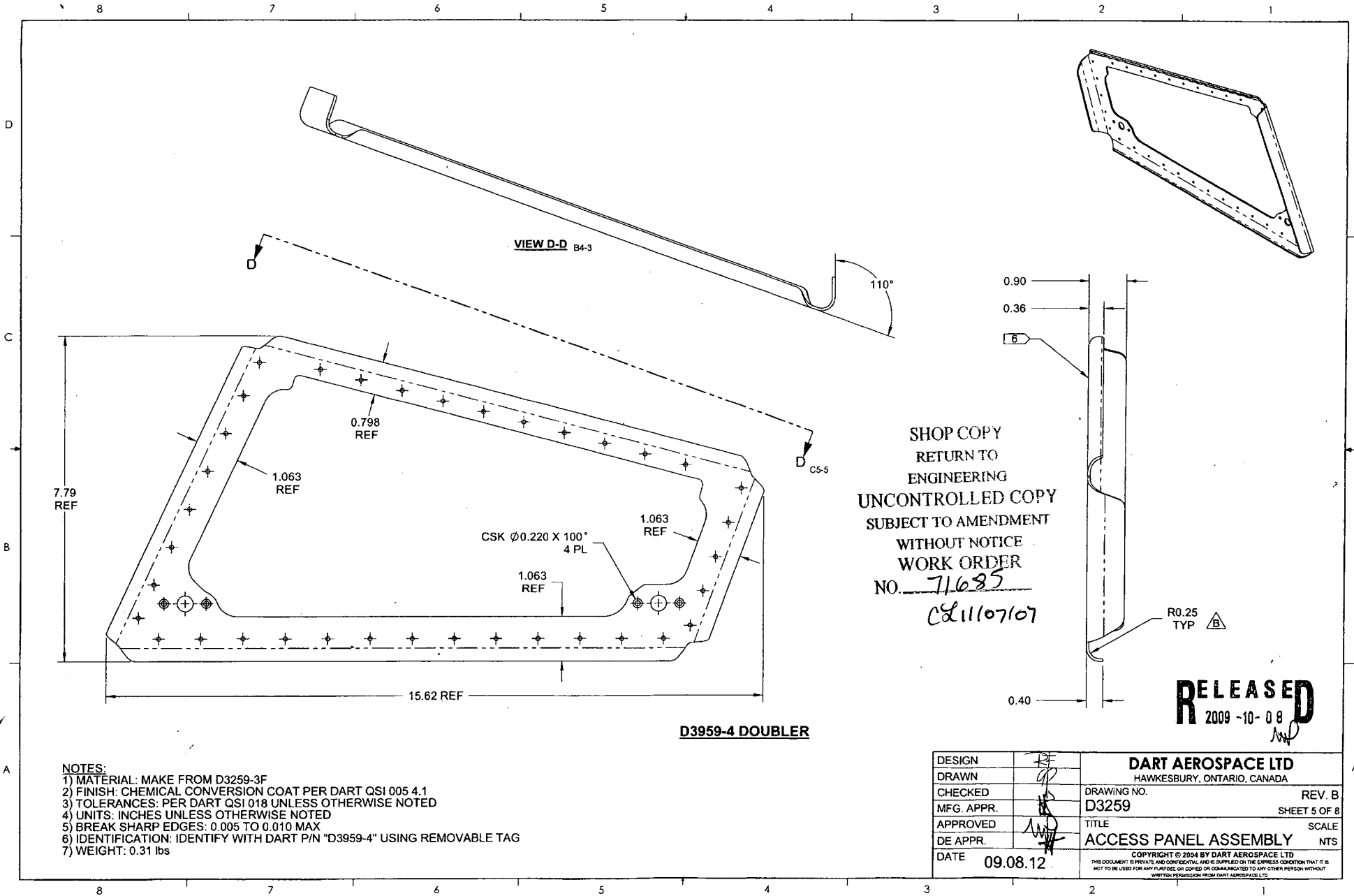
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71685
<b>Description:</b> Doubler		<b>Part Number:</b> D3259-3/-4
<b>Inspection Dwg:</b> D3259 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	8.999	✓		PRO WSOZ	
1.000	+/-0.005	1.000	✓		V FB0Z	
0.260	+/-0.010	.258	✓		V	
R0.25	+/-0.030	.25	✓		R.G	
R0.50	+/-0.030	.50	✓		R.G	
5.000	+/-0.005	4.996	✓		V	
0.875	+/-0.005	.873	✓		V	
12.000	+/-0.005	11.999	✓		P	
3.500	+/-0.005	3.498	✓		V	
0.875	+/-0.005	.876	✓		V	
R0.13	+/-0.030	.13	✓		R.G	
0.500	+/-0.005	.499	✓		V	
0.525	+/-0.005	.524	✓		V	
1.80	+/-0.030	1.804	✓		V	
Ø0.128	+0.005/-0.000	.127	✓		V	
Ø0.377	+0.005/-0.000	.377	✓		V	
Ø0.098	+0.005/-0.000	.099	✓		V	
0.063 thick	+/-0.005	.063	✓		V	
Grain Direction	N/A		✓		V	

<b>Measured by:</b> R	<b>Audited by:</b> S	<b>Preliminary Approval:</b>
<b>Date:</b> 11-8-12	<b>Date:</b> 11/02/12	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	
C	10.08.03	Dimensions updated	KJ	

